

Work Order ID 69588

Thursday, May 12, 2011 2:36:38 PM



Page 1

Item ID:	D3371-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Pedal Lock Assembly					
Start Date:	5/13/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/20/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>11-05-12</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3371	Rev B

120		Small Fab	0.00
Small Fab			
Small Fab			

Memo

- 1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
- 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
- 3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
- 4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	<u>H13436</u>

SD 11/05/24

Ph →

130		Small Fab	0.00
Small Fab			
Small Fab			

Memo

- Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045

EPB 11/05/24 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3371-041 PAR #: N/A Fault Category: Small Job NCR: Yes No DQA: A- Date: 11.05.27
11/05/27 Resolution: Rework Disposition: Rework QA: N/C Closed: ✓ Date: 11/05/27

NCR: <u>69588</u>		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			
<u>11/05/24</u>	<u>120</u>	<u>2 part doesn't fit has to weld 4 holes + redrill to match parts</u> <u>LC: Process</u>	<u>11.05.24</u> <u>OS1042</u>	<u>- Plug Holes</u> <u>Batch Red</u> <u>M115778</u>	<u>(x2)</u>	<u>11.05.24</u>	<u>S</u> <u>11/05/24</u>	<u>11.05.24</u> <u>OS1042</u>	<u>S</u> <u>11/05/24</u>
				<u>- Grind Weld Flush</u>	<u>OS</u> <u>11/05/24</u>	<u>S</u> <u>11/05/24</u>			

NOTE: Date & initial all entries

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3371-041 PAR #: _____ Fault Category: Eng/Design NCR: Yes No DQA: on info 69588 Date: 4 used
 Resolution: Rework Disposition: Rework QA: N/C Closed: _____ Date: 8

NCR: 69923

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/05/24	120	2 part doesn't fit has to weld 4 holes + redrill to match part D.3385-3	11/05/24 GS1042	- Plug Holes Batch Rod M115778	11/05/24	S 11/05/24	11/05/24 GS1042	S 11/05/24
				- Grind Weld Flush	11/05/24	S 11/05/24		

NOTE: Date & initial all entries

Work Order ID 69588

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Page 2

Item ID: D3371-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Pedal Lock Assembly

Start Date: 5/13/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Small Fab

Small Fab

0.00

Memo

0.00

1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371.

2- Identify as D3371-041 & attach keys

3- Record the Key Number on page 4

SD 11/05/24

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/24

160



Packaging

Packaging

Identify as per dwg & Stock Location: 492

0.00

Memo

0.00

C4200

11/5/24 sep

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69588

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Item ID: D3371-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Assembly

Start Date: 5/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/24 JF

MF
11-05-24

C420A Key record

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 69588

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly



Start Date: 5/13/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028 3/16" Dowel Pin .5" long		Purchased	No			120	Each	242.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST399		242							
				106673		98							
				108114		99							
				17848		45							
AN526C832R6 Screw		Purchased	No			120	Each	362.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST327		362							
				16612		362							
AN960-416 Washer	NAS1149F0463P	Purchased	No			140	Each	0.0000	2	2			
CBL-1240 Cable		Purchased	No			130	f	393.0000	1.6666	1.754316			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST284		393							
				113565		93							
				116438		300							

SS 11/6/5/24

4

SS 11/6/5/24

8

M 11/6/702

2 SS 11/6/5/24

SS 11/6/5/24

1.75

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 2:36:33 PM

Page 2

Work Order ID: 69588

Parent Item: D3371-041


Parent Item Name: Pedal Lock Assembly


Start Date: 5/13/2011


Required Date: 5/20/2011


Start Qty: 1.00


Required Qty: 1.00


CBL-460	Purchased	No	130	Each	94.0000	2	2	
								
Loop Sleeve								SS 11/05/24

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST284	94				
			116953	94				
D2728-7	Manufactured	No		120	Each	0.0000	0	0
								
Dart Logo label								SS 11/05/24

D3371-1	Manufactured	No		120	Each	1.0000	1	1
								
Pedal Lock Base								SS 11/05/24

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			st493	1				
			58436	1				
D3371-3	Manufactured	No		120	Each	0.0000	1	1
								
Pedal Lock Cover								SS 11/05/24

D3373-7	Manufactured	No		120	Each	0.0000	1	1
								
Cam Lock								SS 11/05/24

D3384-1	Manufactured	No		130	Each	6.0000	1	1
								
Cyclic Sock								SS 11/05/24

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST486	6				
			58937	6				
								2

Thursday, May 12, 2011 2:36:33 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 2:36:33 PM

Page 3

Work Order ID: 69588



Parent Item: D3371-041



Parent Item Name: Pedal Lock Assembly

Start Date: 5/13/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3385-3

Manufactured No

120

Each

111.0000

1

1



So 11/25/24

Hinge

Location

Loc Qty

Loc Code

ST051

111

22387

111

2

HX-81

Purchased

No

140

Each

33.0000

1

1



So 11/25/24

1/4"-20 SHCS 3/8" long

Location

Loc Qty

Loc Code

ST390

33

114383

33

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

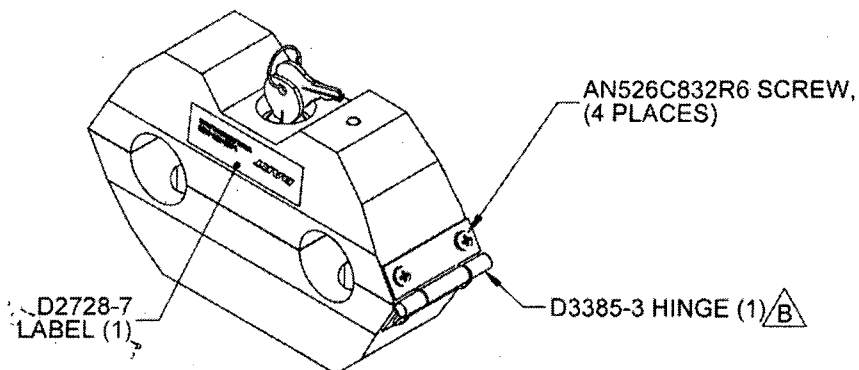
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

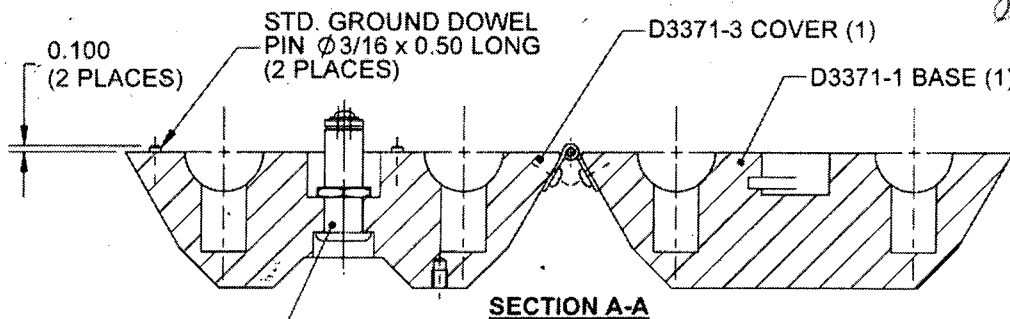


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



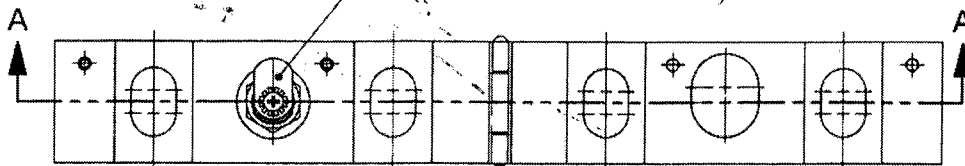
PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



D3373-7 CAM
LOCK ASS'Y

D3371-5 CAM (1),
AND SQUARE WASHER SPACER (1),
EXTERNAL TOOTH LOCK WASHER (1),
#10-32 UNF PAN CROSS HEAD SCREW (1)
(AS PER D3373 DRAWING)



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

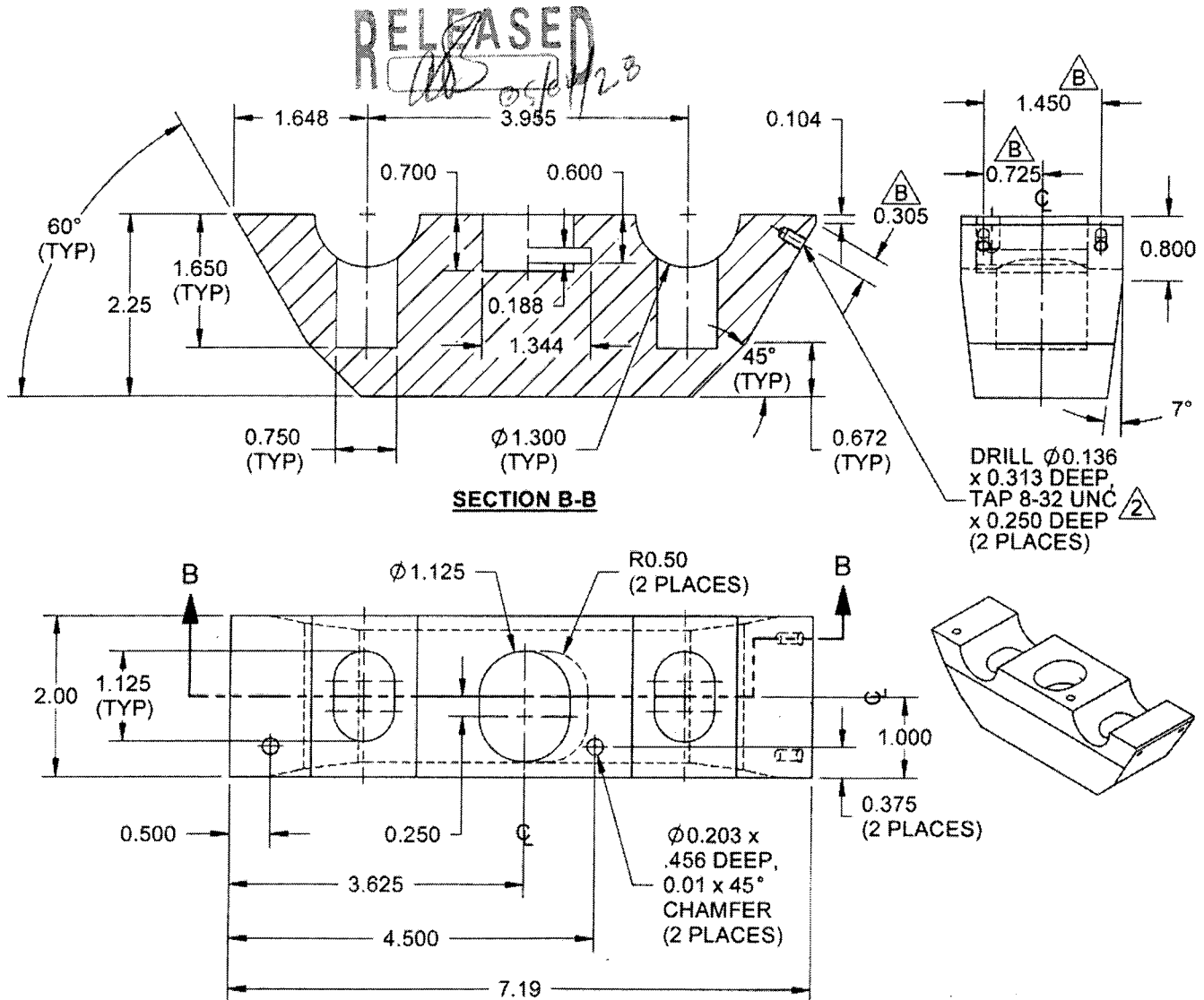
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22	TITLE PEDAL LOCK	SCALE 1:2	



D3371-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

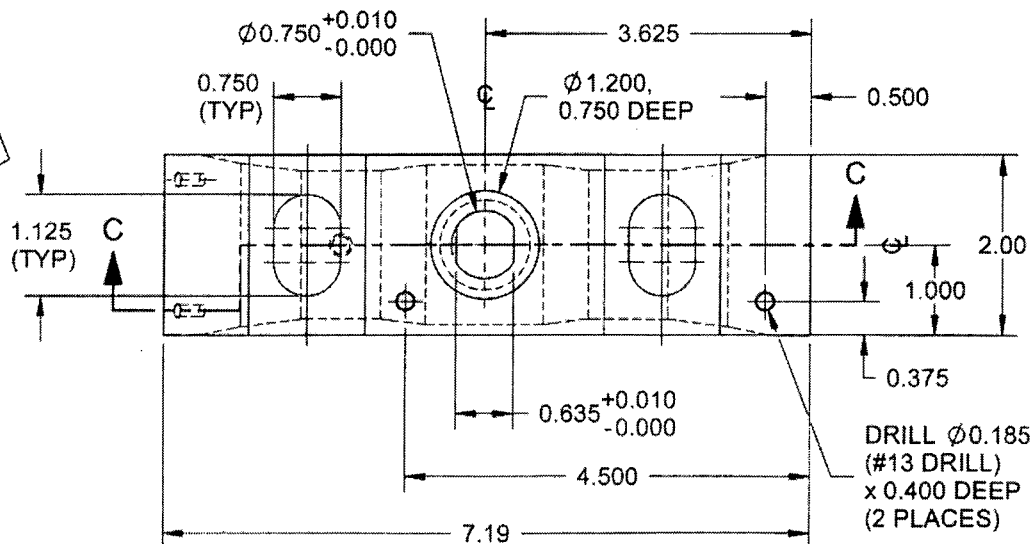
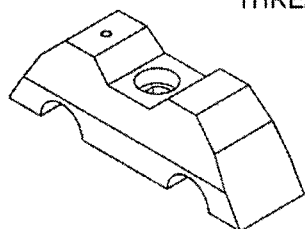
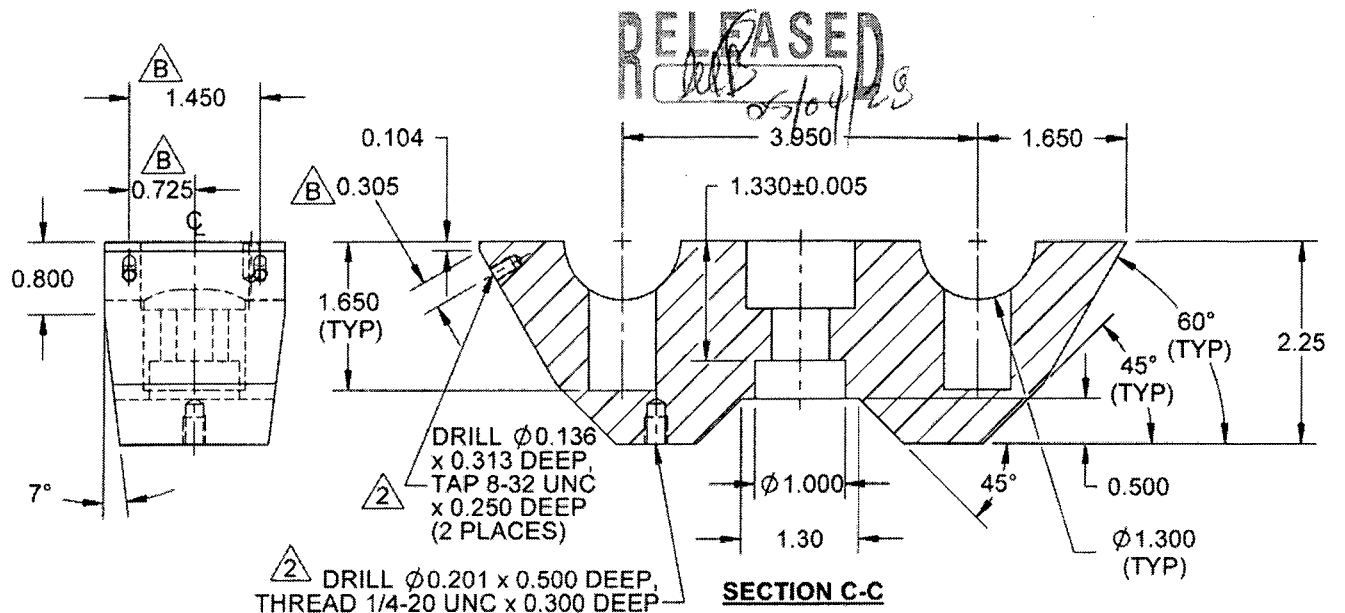
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



D3371-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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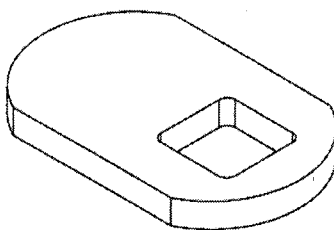
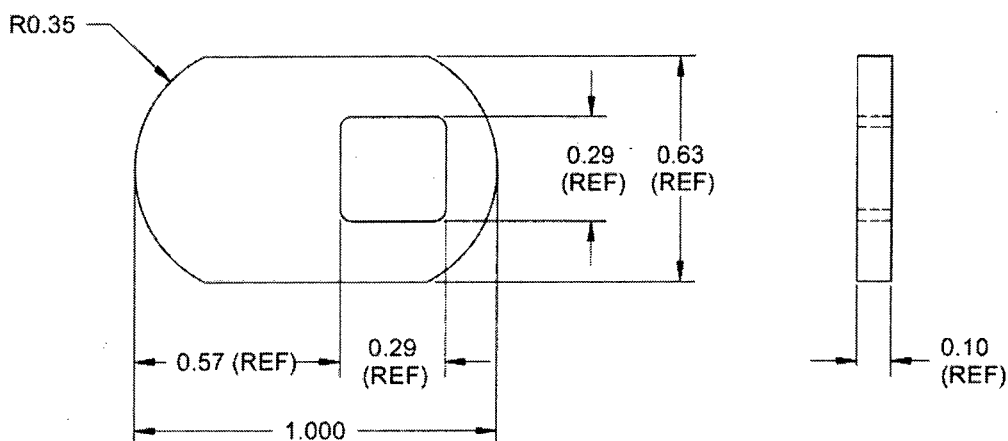
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/28

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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